

Work Order ID 58425

May 6, 2010 2:43:12 PM



Page 1

Item ID:	D2348	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	06/05/2010	Start Qty:	4.00			
Required Date:	13/05/2010	Req'd Qty:	4.00			
Reference:						
Cust Item ID:						
Customer:						

Approvals:	Process Plan:		Date:	10-5-06	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2348	Rev C								

100 FLOW WATER JET 0.00

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D2348
 6061 . 063 Dwg Rev:
 Prog Rev:
 2-Deburr if necessary

MAT NOT PULLED

10-5-07

10/05/31

(17)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00

Quality Control

10-5-07

120 QC8- Inspect parts - second check 0.00

QC Memo 0.00

Quality Control

10/05/31

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58425

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Item ID: D2348

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 06/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Outsource process-Anodize per QSI017 4.1.10.1								
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: 12003 Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached								

EP 10/05/31 (17)

S. d. d. 12/1

40

C2 10/6/12 (17)

W/O:		WORK ORDER CHANGES					
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May 6, 2010 2:43:12 PM



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Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 06/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

INSPECT CERTS

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Insert as per Dwg D2348

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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May 6, 2010 2:43:12 PM



Page 4

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Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 06/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/10/06/10

17

Quality Control

200

Identify as per dwg & Stock Location: 11

0.00



Packaging

Memo

0.00

10-6-10 sl (17)

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/11 17

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 6, 2010 2:43:18 PM

Page 1

Work Order ID: 58425

Parent Item: D2348

Parent Item Name: Wearplate


Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM


Start Date: 06/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	166.9000	0.0198	5		
<div>  <div> <div>6061-T6 .063 Sheet</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div> </div>												

D3996-FE-832-EF		Manufactured	No			180	Each	249.0000	4			
<div>  <div> <div>Self-Clinching Fastener</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div> </div>												

1810-5-27

(17)

112939

EP 10/06/10

68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

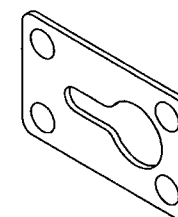
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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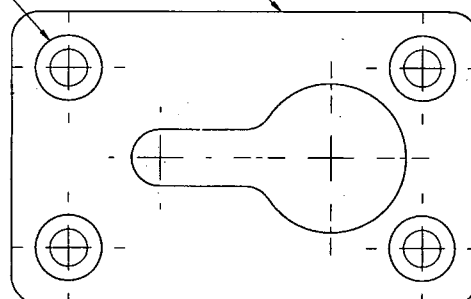
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER



D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

D2348F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58425

BS 10-5-04

D2348 WEAR PLATE

RELEASED
2009-11-09
MA

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>DT</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DT</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DT</i>	D2348	SHEET 1 OF 2
APPROVED	<i>DT</i>	TITLE	SCALE
DE APPR.	<i>DT</i>	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

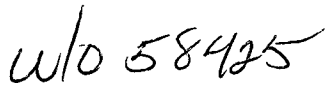
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NOTE: Date & initial all entries



RELEASED
2009-11-08
JAD

DESIGN	SW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2348 TITLE WEAR PLATE COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C
DRAWN	JP		SHEET 2 OF 2
CHECKED	LS		SCALE
MFG. APPR.	[Signature]		NTS
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	09.10.01		

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DART AEROSPACE LTD		Work Order:	58425
Description: Wear Plate		Part Number:	D2348
Inspection Dwg: D2348	Rev: B2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.255	✓			
0.648	+/-0.010	.648	✓			
1.290 .795	+/-0.010 +/-0.005	.796	✓			
2.046	+/-0.010	2.046	✓			
1.295	+/-0.010	1.295	✓			
0.656	+0.005/-0.000	.658	✓			
0.290	+0.005/-0.000	.290	✓			
0.250	+/-0.010	.251	✓			
0.250	+/-0.010	.250	✓			
0.648	+/-0.010	.648	✓			
1.045	+/-0.010					
1.546	+/-0.005	1.547	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-5-27	Date: 10/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12003

Purchase Order Date 6/02/10

PO Print Date 6/02/10

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name

Vendor Phone

514 429 7777

Vendor Fax

514 429 5108

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/2/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	58425	D2348 WEARPLATE	6/11/10 Yes	✓ 17.00	Purolator ground	\$7.3500	\$124.95

Special Inst: BLACK ANODIZE AS PER D3248 REV. C
B58425
ANODIZE AS PER MIL-A-8625F TYPE I
1/1B/1C/11/11B CLASS 2

PO Total:

\$124.95

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 6/02/10

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2

Canada

Phone:514-429-7777 Fax:514-429-5108

EMail:info@tnminc.ca

Packing Slip

DATE

PACKING SLIP #

6/8/2010

- 85748



BILL TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

SHIP TO:

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
12003	0094	NET 30		6/8/2010	Purolator		126130-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
17	17	0	P/N:D2348 TNM-REV:P1 Minimum Charge

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.



Anodisation & Peinture TNM Inc
21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 85748.



6/8/2010

CLIENT / CUSTOMER:

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**

**DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7**

**PURCHASE ORDER /
NO. DE COMMANDE:**

12003

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	17	17	P/N:D2348 TNM-REV:P1 B58425 D2348 B58425	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

Solo/6/10

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air
ambiant.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"



Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager